



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4150-3

Job Sheet 199880



Part No: D4150-3

Job Qty: 20 pcs

DAS
21
9-89

Part Name: Arm Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/4/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/27/19

Description:

Type: Stock

Note: DWG REV B IPP Rev:A 10.06.24 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs	9/27/19	9/27/19	0.17	1.31	Waterjet - Flow		09/19/09/17
120	QC 8	20 pcs	9/27/19	9/27/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
150	Packaging 3-1 - Stock - B4B	20 pcs	9/27/19	9/27/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

DAS
40
9-89

SEP 18 2019

DAS
28
9-89

DAS
28
9-89

				Packaging 3 - 6 - B4B	DAS 28 9-89						
				Packaging 3 - 7 - B4B							
				Packaging 3 - 8 - B4B							
				Packaging 3 - 9 - B4B							
				Packaging 3 - 10 - B4B							
				Packaging 3 - 11 - B4B							
				Packaging 3 - 12 - B4B							
				Packaging 3 - 13 - B4B							
				Packaging 3 - 14 - B4B							
				Packaging 3 - 15 - B4B							
				Packaging 3 - 16 - B4B							
				Packaging 3 - 17 - B4B							
				Packaging 3 - 18 - B4B							
				Packaging 3 - 19 - B4B							
				Packaging 3 - 20 - B4B							
				Packaging 3 - 21 - B4B							
				Packaging 3 - 22 - B4B							
				Packaging 3 - 23 - B4B							
				Packaging 3 - 24 - B4B							
				Packaging 3 - 25 - B4B							
				Packaging 3 - 26 - B4B							
				Packaging 3 - 27 - B4B							
				Packaging 3 - 28 - B4B							
				Packaging 3 - 29 - B4B							
				Packaging 3 - 30 - B4B							
				Packaging 3 - 31 - B4B							
				Packaging 3 - 32 - B4B							
				Packaging 3 - 33 - B4B							
				Packaging 3 - 34 - B4B							
				Packaging 3 - 35 - B4B							
				Packaging 3 - 36 - B4B							
				160		QC 21 - SA	20 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21	DAS
										QC 21 - SA - 70	21
										QC 21 - SA - 53	9-89

SEP 18 2019

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	.5080 sf (.0254 ea)	100-Waterjet - Flow - 1	5159397

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	1	19	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm Plate	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
2	Arm Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
3	Arm Plate	1.000Inches ± 0.010	1.010 0.990		
4	Arm Plate	0.968Inches ± 0.010	0.978 0.958		
5	Arm Plate	0.375Inches ± 0.010	0.385 0.365		
6	Arm Plate	0.300Inches ± 0.010	0.310 0.290		
7	Arm Plate	0.800Inches ± 0.010	0.810 0.790		
8	Arm Plate	1.590Inches ± 0.030	1.620 1.560		
9	Arm Plate	2.340Inches ± 0.030	2.370 2.310		
10	Arm Plate	0.750Inches ± 0.030	0.780 0.720		
11	Arm Plate	1.560Inches ± 0.030	1.590 1.530		
12	Arm Plate	1.188Inches ± 0.010	1.198 1.178		
13	Arm Plate	0.125Inches ± 0.010	0.135 0.115		

Plex 9/4/19 9:03 AM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework Scrap Use-as-Is	Cross tube Small Fab Finishing	Skid-tube Machining Large Fab	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering Water Jet Supplier Quality
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		MRB (QSI042)			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors	Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:	Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function	Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up	Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	